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(54) Composition for cross-linking carboxyl polymers and the use thereof in treating subterranean formations.

(57) Water dispersible, hydrophilic, organic polymers having a molecular weight greater than 100,000 and containing carboxyl functionality, are cross-linked using a composition comprising water, a tetravalent zirconium compound, an alpha-hydroxy acid and an amine. By contacting subterranean formations with such cross-linked polymers, the permeability of the formations is reduced which, in the case of oil wells, improves secondary and tertiary oil recovery techniques.

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COMPOSITION FOR CROSS-LINKING CARBOXYL POLYMERS AND THE  
USE THEREOF IN TREATING SUBTERRANEAN FORMATIONS

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This invention relates to a method of treating a subterranean formation to reduce its permeability to water, and to compositions for cross-linking polymers useful for this purpose.

5           Only a portion of the oil contained in a subterranean reservoir can be recovered by primary methods, and it has therefore become general practice to employ various secondary or tertiary recovery techniques to produce the additional quantities of oil not economically recovered by  
10 primary methods. Of the various secondary or tertiary recovery methods available, one of the most widely practised techniques is the displacement of oil from the reservoir with a driving fluid such as a floodwater injected for that purpose. Normally, in carrying out the flooding process, input or  
15 injection wells are utilized. These wells can be old existing wells or can be wells which are newly drilled into the oil-producing strata. The injection wells locations with reference to the production wells are selected to afford a desired flood pattern, the selected pattern depending in  
20 part upon field conditions, the locations of existing wells, and the operator's preference. Aqueous drive fluids, such as water, brine or a viscous aqueous fluid are forced into the input wells under pressure, and out into the surrounding oil bearing strata towards the producing well or wells. While  
25 waterflooding has been rather widely practised in recent years,

it is not without considerable operating problems and economical limitations, particularly those associated with low oil recoveries in proportion to the amount of water injected. Various surfactant and solvent floods have been proposed as means for recovering additional quantities of oil over that recoverable by conventional waterflooding. However, these processes face serious operating problems when practised in heterogeneous formations containing strata or channels having permeability substantially higher than the bulk of the formation.

One of the major problems encountered in a flooding operation is the breakthrough of the flooding medium from the flood front to the producing well relatively early in the displacement process, and rapidly increasing producing water/oil ratios following the initial breakthrough. These difficulties result from the displacing medium channeling or fingering through the oil-bearing structure to the producing well, thus bypassing large zones of the oil-bearing strata. The reason for the channeling of the flooding medium to the producing wells and the resulting low oil recovery is due in part to the peculiar structure of the oil-bearing strata. Underground oil reservoirs, in most cases, consist of layers of sand or rock and, since no reservoir rock is perfectly uniform in composition and structure, the permeability will vary across the rock face or strata. Also, fractures, cracks, and other abnormalities can promote channeling of the displacement of the fluid.

In the normal flooding operation, maximum oil recovery is obtained when the driven fluid goes up in a wide bank in front of the driving fluid which moves uniformly towards the producing well. To keep this bank of oil intact and constantly moving towards the producing well, a substantially uniform permeability must exist throughout the strata. If this uniform permeability does not exist, or is not provided, the flooding fluid will seek the areas of high

permeability, and channeling occurs with the subsequent loss of some driving fluid energy and the appearance of excessive amounts of driving fluid in the producing well. Moreover, as the more permeable strata are depleted, the driving fluid has a tendency to follow channels and further increase the consumption of the flooding medium to the point where the process becomes uneconomical. It is, therefore, desirable to operate at a drive fluid to oil ratio that is as low as possible.

Another problem associated with the production of oil from oil-bearing formations containing highly permeable water channels communicating the production well with the water zone is the intrusion of water into the well. Not only does this water intrusion cause production and disposal problems, but more importantly the beneficial effect of the natural water drive is at least, in part, lost thereby adversely affecting oil recovery.

It is advantageous to reduce the permeability of the water channels so as to render the formation more uniformly permeable and to increase the unit efficiency of the water drive, or alternatively to shut off the water intrusion.

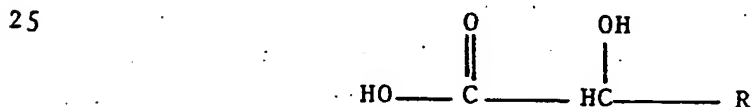
Many processes have been proposed for reducing the permeability of a subterranean formation. For instance, U.S. Patent 3,762,476 discloses that the quantity of water recovered from a subterranean formation penetrated by a well bore can be reduced by injecting into the subterranean formation a first thickened aqueous solution, a complexing ionic solution of multivalent cations and retarding anions, a brine slug, and a second thickened aqueous solution. Complexing ionic solutions disclosed in the patent have a multivalent metal cation selected from the group consisting of  $\text{Fe}^{2+}$ ,  $\text{Fe}^{3+}$ ,  $\text{Al}^{3+}$ ,  $\text{Ti}^{4+}$ ,  $\text{Zn}^{2+}$ ,  $\text{Sn}^{4+}$ ,  $\text{Ca}^{2+}$ ,  $\text{Mg}^{2+}$ , and  $\text{Cr}^{3+}$  and a retarding anion selected from the group consisting of acetate, nitrilotriacetate, tartrate, citrate and phosphate.

U.S. Patent 3,833,061 discloses a method for selectively reducing the permeability of an oil-wet subterranean formation penetrated by at least one well bore by passing an oxidizing agent through and into contact with the formation for oxidizing and removing hydrocarbons from the surfaces of the formation and thereafter contacting the treated formation surfaces with a crosslinked polymer. The patent discloses the use of aluminum citrate as a crosslinking composition.

We have now found that the permeability to water of subterranean formations can be modified advantageously by treating the formations with mixtures of carboxyl functionality polymers and certain crosslinking compositions which we have devised.

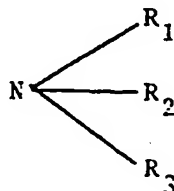
According to the invention, there is provided a composition for crosslinking a polymer which contains carboxyl functionality, which composition comprises:

- (1) water;
- (2) one or more of the zirconium compounds: zirconium oxychloride, zirconium acetate, zirconium tetrachloride, zirconium ortho-sulfate, zirconium carbonate and zirconium ammonium carbonate;
- (3) one or more alpha-hydroxy acids of the formula:



wherein R is hydrogen or an alkyl group having 1 to 3 carbon atoms; and

- (4) one or more amines of the formula:



wherein  $R_1$  is a hydroxyalkyl group having 1 to 3 carbon atoms;

$R_2$  is an alkyl or hydroxyalkyl group having 1 to 3 carbon atoms; and,

5  $R_3$  is hydrogen or an alkyl or hydroxyalkyl group having 1 to 3 carbon atoms.

These compositions are particularly useful for crosslinking water dispersible, hydrophilic, organic polymers having a molecular weight greater than 100,000 and containing  
10 carboxyl functionality.

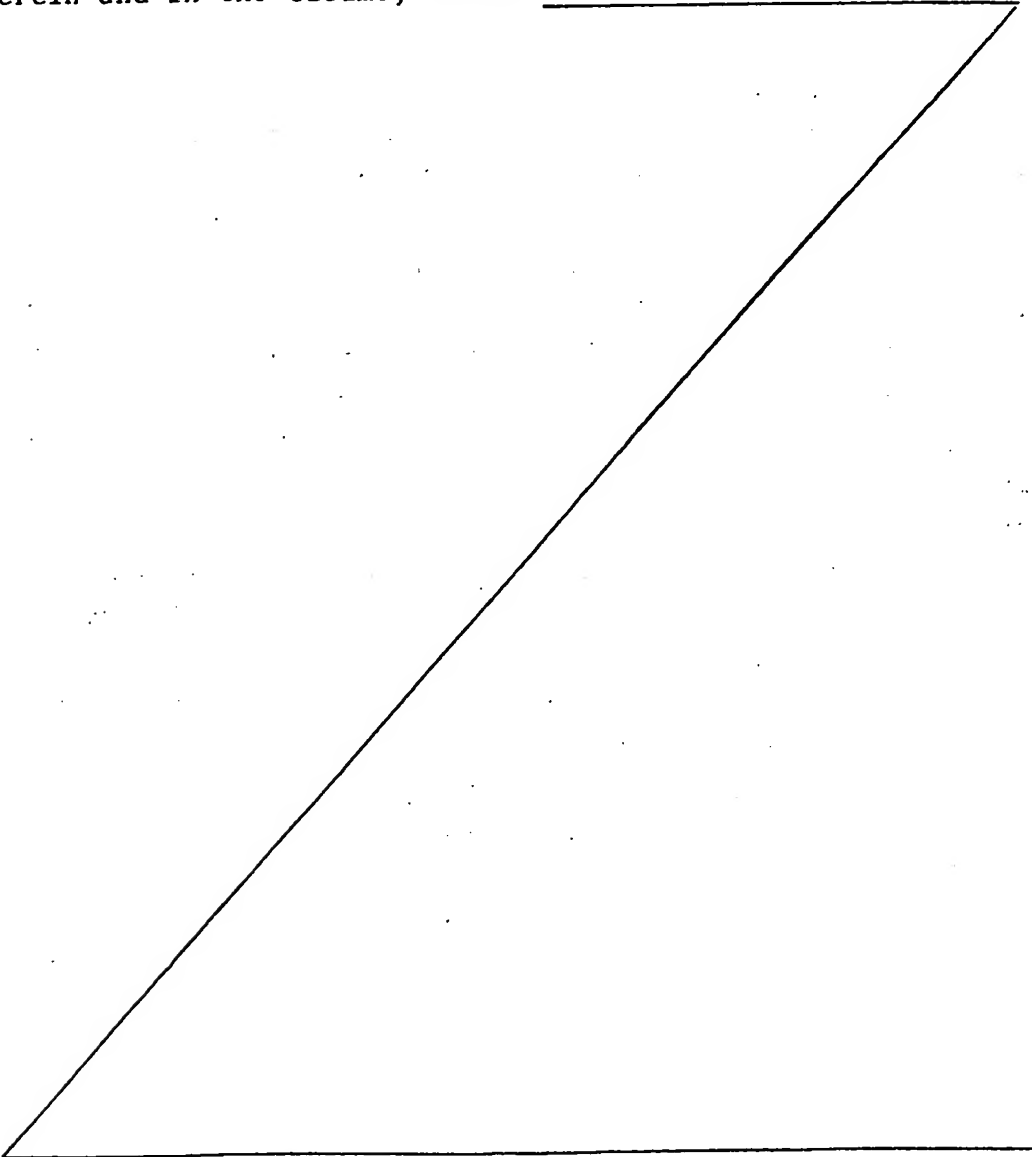
The permeability of a subterranean formation penetrated by at least one well bore is reduced, in accordance with the invention, by treating the formation surfaces with a mixture of the polymer and the crosslinking  
15 composition. The method of the invention can be used in either injection wells of water floods or hydrocarbon production wells, for example for the purpose of reducing the water-oil ratio produced therefrom, e.g. reduce the mobility of water in the wellbore area.

20 In one preferred embodiment of the invention, the subterranean formation is contacted sequentially first with water and the water dispersible hydrophilic organic polymer, then with the crosslinking composition, and finally with a second mixture of water and the hydrophilic organic  
25 polymer.

Polymers suitable for use in the present invention can generally be described as water dispersible hydrophilic organic polymers having a molecular weight greater than 100,000 and containing carboxyl functionality whereby the  
30 polymers can be crosslinked with zirconium compounds having a valence of +4. Examples of such polymers include carboxyalkyl guar wherein the alkyl group has 1 to 3 carbon atoms, carboxyalkylhydroxyalkyl guar wherein the alkyl groups have 1 to 3 carbon atoms, xanthan gum, polyacrylamide and  
35 polymethacrylamide wherein from 5 to 75 percent of the

carboxylamide groups of the polyacrylamide and polymethacrylamide are hydrolyzed to carboxyl groups, cellulose ether polymers containing carboxyl functionality, and copolymers resulting from the polymerization of acrylamide  
5 or methacrylamide with acrylic acid and/or methacrylic acid.

The polymers used are preferably substantially free of crosslinking between the polymer chains. As used herein and in the claims, unless



otherwise specified, the term "hydrolyzed" includes modified polymers wherein the carboxyl groups are in the acid form and also polymers wherein the carboxyl groups are in the salt form, provided such salts are water dispersible. Such salts  
5 include ammonium salts, alkali metal salts, and others which are water dispersible. Hydrolysis can be carried out in any suitable fashion, for example, by heating an aqueous solution of the polymer with a suitable amount of sodium hydroxide.

Examples of cellulose ethers which can be used to carry  
10 out the invention include, for example, carboxyalkyl cellulose ethers such as carboxymethyl cellulose (CMC), and mixed ethers such as carboxyalkylhydroxyalkyl cellulose ethers such as carboxymethylhydroxyethyl cellulose (CMHEC). Many of these cellulose ethers that contain carboxyl functionality  
15 are commercially available and are available as the alkali metal salt, usually the sodium salt. The metal is seldom referred to and they are commonly referred to as CMC or CMHEC.

The copolymers of acrylic acid, methacrylic acid or combinations thereof with acrylamide, methacrylamide or combinations thereof are made up with from about 5 to 70 percent  
20 by weight of acrylic acid, methacrylic acid and combinations thereof and most preferably from about 10 to about 40 percent by weight of acrylic acid, methacrylic acid and combinations thereof.  
25

Included among the polyacrylamides that can be used in



the present invention are polyacrylamides and related polymers which are water soluble. Presently preferred polymers include homopolymers and copolymers of acrylamide and methacrylamide. These polymers can contain from about 5 percent to about 75 percent and preferably about 40 percent of the carboxamide groups hydrolyzed to carboxyl groups.

The most preferred polymer for carrying out the method of the invention is polyacrylamide wherein 7 percent or 30 percent of the carboxamide groups are hydrolyzed to carboxyl groups. The amount of carboxyl functionality will depend on the formation to be treated.

Mixtures of the above-described polymers can be used in the practice of the invention.

The polymers must have a molecular weight of at least 100,000, but the upper limit of the molecular weight is not critical as long as the polymer is water dispersible and the aqueous gel prepared therefrom can be pumped. Thus, polymers having a molecular weight as high as 20 million or higher, in many said conditions can be used.

The amount of the polymers used in the practice of the invention can vary widely depending on the particular polymer desired, purity of the polymer, and the properties desired in the gels. Generally speaking, amounts in the range of from 0.0025 to about 5.0, preferably from 0.01 to 1.5, or preferably 0.025 to about 0.4 weight percent based on the weight of water can be used. Amounts outside this range, however,

can be used. Small amounts of polymer will usually produce liquid mobile gels which can be readily pumped where as large amounts of polymer will usually produce thick, viscous, somewhat elastic gels. The thick gels can be thinned by  
5 the dissolution of water to any desired concentration of polymer and this can be done by mechanical means such as stirring, pumping, or by means of a suitable turbulence inducing device to cause shearing such as a jet nozzle. Thus, there is really no fixed upper limit on the amount of  
10 polymer which can be used.

The preferred zirconium compound in the cross-linking compositions of the invention is zirconium oxychloride. Examples of suitable alpha-hydroxy acids which can be utilized in the present invention are lactic acid and  
15 glycolic acid, the preferred acid being lactic acid.

Examples of suitable amines are diethanolamine, triethanolamine, and dimethylethanolamine. The preferred amine is triethanolamine.

At elevated temperatures, it is sometimes  
20 desirable that the crosslinking composition be delayed for longer periods of time in which case citric acid or malic acid (or both) can advantageously be added to the composition.

The zirconium compound used in the crosslinking  
25 composition has a +4 valence. Although the crosslinking mechanism is not totally understood, it is believed that the valence of the zirconium compound does not change during the crosslinking of the composition with the polymers.

While it is not intended to limit the invention  
30 by any theories as to the nature of the mechanisms, it is presently believed that the amine and acid used in the crosslinking composition complex with, chelate, or otherwise react with the zirconium ions having a valence of +4. It is believed that amine and acid are thus in competition with  
35 the polymers and temporarily reduce the number of ions

available for reaction with the polymer and thus delay the crosslinking reaction.

The quantity of zirconium compound having a valence of +4, acid and amine used in the crosslinking compositions of the present invention may vary over a wide range. Generally, for 1 mole of zirconium metal ion, there will be used about 2 to about 5 moles of the alpha-hydroxy acid and about 1 to 5 moles of the amine. When citric acid or malic acid are also present, about .25 moles to about 2 moles are utilized per 1 mole of zirconium metal ion. A particularly preferred crosslinking composition comprises zirconium oxychloride and, for each one mole of zirconium metal ion having a valence of +4, about 2 moles of lactic acid, and about 2 moles of triethanolamine. When it is desired to add citric acid or malic acid to such a composition, preferably about 0.25 moles are added.

The amount of crosslinking composition used to carry out the method of the invention will vary over a wide range and therefore the amounts will vary according to the formation to be treated. Usually, however, good results have been achieved when the crosslinking composition is employed in amounts of from about 1.0 to about 100.0, more preferably, from about 2.0 to about 50.0, percent by weight of the total polymer.

The crosslinking composition is prepared preferably by adding to an amount of water which is sufficient to allow sufficient mixing of ingredients of the crosslinking composition the alpha-hydroxy acid and adjusting the pH of the acid mixture from about 5 to about 8, and preferably 7, with a basic compound such as sodium hydroxide or preferably ammonium hydroxide to form a first mixture. The zirconium compound, when zirconium oxychloride, zirconium acetate, \_\_\_\_\_

zirconium ortho-sulfate and zirconium tetrachloride are utilized, is preferably the next ingredient added to the first mixture to form a second mixture. Finally the amine compound is preferably added to the second mixture containing the zirconium compound to form a third mixture. The pH of the second mixture can be adjusted using a basic compound such as sodium hydroxide or preferably ammonium hydroxide or the pH of the second mixture can be adjusted by the addition of the amine compound. Although the crosslinking composition can be used at a pH greater than 8 or less than 5, it is important that the mixing of the first and second mixtures be carried out at a pH from about 5 to about 8, and preferably at about 7. When citric acid or malic acid is utilized in the crosslinking composition, it is added to the third mixture after the pH has been adjusted from about 5 to about 8.

When zirconium carbonate or zirconium ammonium carbonate is utilized in the crosslinking composition, the crosslinking composition is preferably prepared by first adding the zirconium carbonate or the zirconium ammonium carbonate to water to form a first mixture, next adding the amine compound to the first mixture to form a second mixture, and adjusting the pH of the second mixture from about 5 to about 8, usually with an acid such as hydrochloric acid, and, finally adding the alpha-hydroxy acid to the second mixture to form a third mixture and adjusting the pH of the third mixture from about 5 to about 8.

The term "water" is used generally herein and in the Claims, unless otherwise specified, to include brines and fresh water.

5 On some occasions, the surfaces of the formation to be treated are covered with materials such as hydrocarbons. If this covering is removed from the surface prior to the treatment, a treatment wherein the permeability of the formation is reduced is better achieved. Therefore, sometimes an agent is utilized which removes the hydrocarbons from the surfaces  
10 of the formation prior to the treatment. Agents which can be used include oxidizing agents such as hydrogen peroxide, potassium permanganate, nitric acid, and the like. These agents are well known in the art and the selection of the agent will depend on the formation to be treated.

15 The polymer solutions can be prepared in either fresh-water or brine. Any suitable procedure for preparing the polymer solution can be used.

In one embodiment of the present invention, the mixture comprising water and the water dispersible hydrophilic organic polymers having a molecular weight greater than 100,000  
20 and containing carboxyl functionality are mixed with the crosslinking composition and the resulting mixture is injected through a well into the subterranean formation. The mixture is directed to that portion of the subterranean formation where it is desired that the permeability be altered.  
25 After the injection of the above-described mixture, a spacer

fluid is preferably injected into the well to displace the mixture from the tubing and out into the formation.

Preferably the volume of the spacer fluid is the volume needed to displace all the treating fluids out in the formation plus five barrels per vertical foot ( $2607\text{m}^3$  per vertical metre) of interval to be treated. The well is then preferably shut in for about 48 hours.

In another embodiment of the present invention, a first mixture comprising water and a water dispersible hydrophilic organic polymer having a molecular weight greater than 100,000 and containing carboxyl functionality is injected through a well into the subterranean formation whereby the polymer contacts that portion of the formation where the change in permeability is desired. Optionally, a spacer fluid such as a brine solution is next injected into the well and thus contacts the formation. After the spacer fluid injection is completed, the crosslinking compound containing the zirconium compound having a valence of +4, amine, and alpha-hydroxy acid is injected into the well bore and into the formation whereby the crosslinking composition contacts the polymer in the formation. Finally, a second mixture comprising water and a water dispersible hydrophilic organic polymer having a molecular weight greater than 100,000 and containing carboxyl functionality is injected into the well and into the formation. The steps of injecting the crosslinking composition and the second organic polymer can

be repeated if necessary. This embodiment is used primarily for treating waterflood injection wells.

Spacer fluids that can be used in the present invention are well known in the art and include brine  
5 solutions, alkali metal halide solutions and the like.

The amount of total polymer used to carry out the method of the present invention will vary over a wide range depending upon the formation to be treated.

In order that the invention may be more fully  
10 understood, the following Examples are given by way of illustration only.

#### EXAMPLE 1

A series of aqueous gels were prepared using the crosslinking composition of the present invention and various  
15 polymers.

The crosslinking composition used in Tests 1 through 6 and 9 through 13 was prepared by adding the alpha-hydroxy acid to water to form a first mixture, and adjusting the pH of the first mixture to about 7, adding the zirconium  
20 compound to the first mixture to form a second mixture, and adding the amine to the second mixture to form a final mixture and adjusting the pH of the final mixture to about 7.

The crosslinking composition used in Test 7 was prepared by adding an aqueous solution of lactic acid to  
25 zirconium acetate to form a first mixture, heating the first mixture to about 110°F (43°C) for 10 minutes, adjusting the pH of the first mixture to about 6, and adding the amine to the first mixture to form a second mixture. The pH of the second mixture was checked to ensure a final pH of about 7.

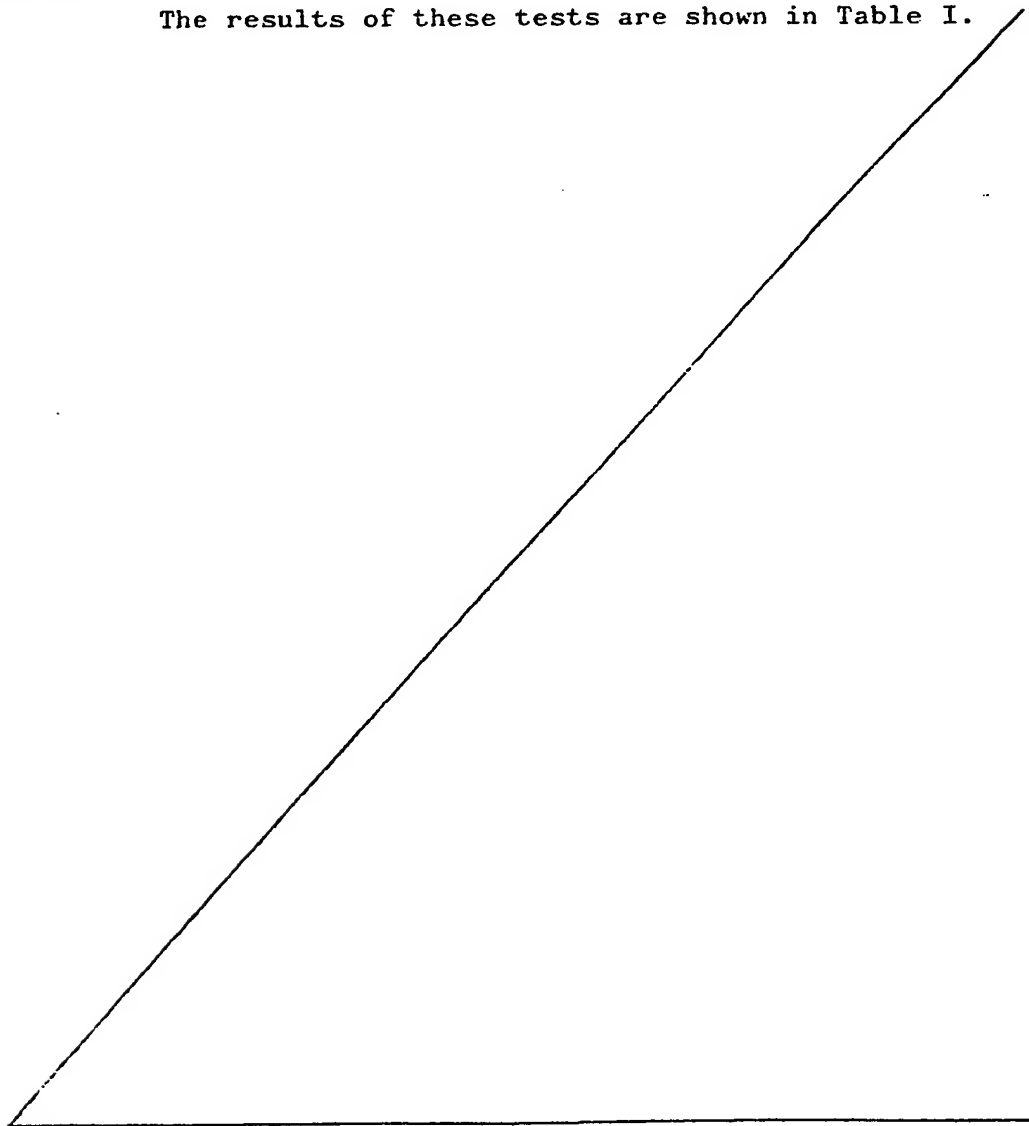
30 The crosslinking composition used in Test 8 was prepared by adding zirconium carbonate to water to form a first mixture, adding triethanolamine to the first mixture to form a second mixture and adjusting the pH of the second mixture to about 7 with hydrochloric acid and adding lactic  
35 acid to the second mixture to form a third mixture and

adjusting the pH of the third mixture to about 7.

The crosslinking composition was added to an aqueous polymer solution. The crosslinking composition and polymer were then mixed at ambient temperature except  
5 for Test 8.

The crosslinking of the polymer by the cross-linking composition was visually determined by observing at a specific time the increase in viscosity of the solution containing the crosslinking composition and the  
10 polymer.

The results of these tests are shown in Table I.





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TABLE I

Test No.	Crosslinking Compound			Polymer (%) Hydrolyzed	Weight Ratio of Crosslinking Compound to Polymers	Gelling Time (Min.)	Remarks
	Zirconium Compound (1 mole)	Alphahydroxy Acid (moles used)	Amine (moles used)				
1	Zirconium Oxychloride	lactic acid (2)	triethanolamine (1)	polyacrylamide (9%)	140 / 2,000	40	Stable gel without precipitate
2	Zirconium Oxychloride	lactic acid (2)	triethanolamine (2)	polyacrylamide (9%)	100 / 2,500		Stable gel without precipitate
3	Zirconium Oxychloride	lactic acid (3)	triethanolamine (1)	polyacrylamide (9%)	100 / 2,500	20	Stable gel without precipitate
4	Zirconium Oxychloride	lactic acid (3)	diethanolamine (1)	polyacrylamide (9%)	100 / 2,500	10	Stable gel without precipitate
5	Zirconium Oxychloride	lactic acid (3)	dimethyl-ethanolamine (1)	polyacrylamide (9%)	100 / 2,500	20	Stable gel without precipitate
6	Zirconium Oxychloride	Glycolic Acid (3)	triethanolamine (1)	polyacrylamide (9%)	100 / 2,500	15	Stable gel without precipitate
7	Zirconium Acetate	lactic acid (3)	triethanolamine (1)	polyacrylamide (9%)	100 / 2,500	15	Stable gel without precipitate
8	Zirconium Carbonate	lactic acid (3)	triethanolamine (1)	polyacrylamide (9%)	100 / 2,500	15 - 20*	Stable gel without precipitate

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TABLE I  
(Continued)

Test No.	Crosslinking Compound			Polymer (% hydrolyzed)	Weight Ratio of Crosslinking Compound to Polymers	Gelling Time (Min.)	Remarks
	Zirconium Compound (1 mole)	Alphahydroxy Acid (moles used)	Amine (moles used)				
9	Zirconium Oxychloride	Lactic acid (3)	triethanolamine (1)	carboxymethyl cellulose DS = 0.9	150 / 6,000	1	Stable gel without precipitate
10	Zirconium Oxychloride	Lactic acid (3)	triethanolamine (1)	carboxymethylhydroxyethyl cellulose DS = 0.4 MS = 2.0	150 / 6,000	10	Stable gel without precipitate
11	Zirconium Oxychloride	Lactic acid (3)	triethanolamine (1)	carboxymethylhydroxypropyl guar DS = 0.3 MS = 0.6	150 / 6,000	1	Stable gel without precipitate
12	Zirconium Oxychloride	Lactic acid (3)	triethanolamine (1)	hydroxypropyl guar MS = 0.4	150 / 6,000	2	Stable gel without precipitate
13	Zirconium Oxychloride	Lactic acid (3)	triethanolamine (1)	Xanthan	100 / 5,000	2	Stable gel without precipitate

\* Tests carried out at 180°F.

EXAMPLE II

A test was conducted to determine the residual resistance factor (RRF) of two cores using the method of the present invention. The cores were connected in series with one another and contained Healdton Sand from Carter County, Oklahoma, and were about 15/16" (2.4 cm) in diameter and about 2" (5.1 cm) in length.

The test was carried out by the following steps:

- a. Pump through the cores a brine solution until a constant flow rate of 1 ml/min was achieved.

The brine solution had the following composition:

<u>Salt</u>	<u>g/l</u>
NaCl	52.3
CaCl <sub>2</sub>	11.96
MgCl <sub>2</sub> ·6H <sub>2</sub> O	6.52
NaHCO <sub>3</sub>	0.45

- b. Pump through the cores at a constant flow rate of 1 ml/min an aqueous solution comprising 500 ppm of a copolymer of 90% by weight polyacrylamide and 10% by weight acrylic acid and 2% by weight of a crosslinking composition. The crosslinking composition comprised 1 mole of zirconium oxychloride, 3 moles of lactic acid, and 1 mole of triethanolamine. Eight pore

volumes (based on the pore volume of both cores) of the aqueous solution were pumped through the cores.

c. Shut in the cores overnight.

5 d. Pumped a brine solution through the cores until a constant flow rate of 1 ml/min was achieved.

The results of this test were measured in residual resistance factor (RRF).

10 
$$RRF = \frac{\text{permeability before treatment}}{\text{permeability after treatment}}$$

The permeabilities for the RRF were measured by the pumping pressure through the cores, before and after treatment.

15 The RRF after treatment for the first core leveled off at about 12.9 and the RRF leveled off for the second core, which was the second core connected in the series, to about 5.5.

### EXAMPLE III

20 A test was conducted to determine the residual resistance factor (RRF) of two cores using the method of the present invention. The cores were connected in series with one another, contained standard Berea sandstone, and were about 15/16" (2.4 cm) in diameter and about 4" (10.2 cm) in length.

25 The test was carried out by the following steps:

- a. Pump through the cores a brine solution until a constant flow rate of 1 ml/min. was achieved. The brine solution had the following composition:

5	<u>Salt</u>	<u>g/l</u>
	NaCl	69.3
	CaCl <sub>2</sub>	5.3
	MgCl <sub>2</sub> ·6H <sub>2</sub> O	4.0

- 10 b. Pump through the cores at a constant flow rate of 1 ml/min. About 2.5 pore volumes (based on the pore volume of both cores) of an aqueous solution comprising 1,000 ppm of a polymer comprising 30 percent hydrolyzed polyacrylamide.
- 15 c. Pump through the cores at a constant flow rate of 1 ml/min one pore volume (based on the pore volume of both cores) of a brine solution. The brine solution had the same composition as the brine of Step a.
- 20 d. Pump through the cores, at a constant flow rate of 1 ml/min, 1.5 pore volume (based on the pore volume of both cores) of an aqueous solution comprising 500 ppm of a crosslinking composition. The crosslinking composition had
- 25 the same ingredients and proportions as the

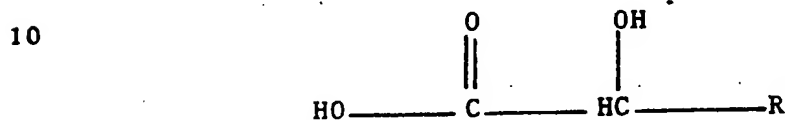
crosslinking composition of Step b of Example II.

- 5 e. Pump through both cores, at a constant flow rate of 1 ml/min one pore volume (based on the pore volume of both cores) of a brine solution. The brine solution had the same composition as the brine of Steps a and c.
  - 10 f. Pump through the cores, at a constant flow rate of 1 ml/min. About 2.5 pore volumes (based on the pore volume of both cores) of an aqueous solution comprising 1,000 ppm of a polymer comprising 30 percent hydrolyzed polyacrylamide.
  - g. Shut in the cores overnight.
  - 15 h. Pump a brine solution through the cores until a constant flow rate of 1 ml/min was achieved.
- The results of the test were measured in residual resistance factor (RRF) in the same manner as Example II.
- The RRF of the first core leveled off at about 22.5 and the RRF of the second core leveled off at about 3.8.

CLAIMS:

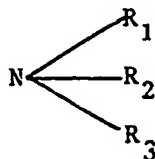
1. A composition for crosslinking a polymer which contains carboxyl functionality, which composition comprises:

- (1) water;
- (2) one or more of the zirconium compounds: zirconium oxychloride, zirconium acetate, zirconium tetrachloride, zirconium ortho-sulfate, zirconium carbonate and zirconium ammonium carbonate;
- (3) one or more alpha-hydroxy acids of the formula:



wherein R is hydrogen or an alkyl group having 1 to 3 carbon atoms; and

- (4) one or more amines of the formula:



wherein  $\text{R}_1$  is a hydroxyalkyl group having 1 to 3 carbon atoms;

$\text{R}_2$  is an alkyl or hydroxyalkyl group having 1 to 3 carbon atoms;

and,

$\text{R}_3$  is hydrogen or an alkyl or hydroxyalkyl group having 1 to 3 carbon atoms.

2. A composition according to Claim 1, which comprises lactic acid or glycolic acid, or a mixture of these two alpha-hydroxy acids.

3. A composition according to Claim 1 or 2, which comprises diethanolamine, triethanolamine or dimethylethanolamine, or any mixture of two or all of these amines.
- 5 4. A composition according to Claim 1,2 or 3, in which the proportions are 2 to 5 moles of the alpha-hydroxy acid(s), and 1 to 5 moles of the amine(s) for each 1 mole of zirconium metal ion.
- 10 5. A composition according to Claim 1,2,3 or 4, which also contains citric acid or malic acid or a mixture of the two, the proportions of these two acids being from 0.25 moles to 2 moles for each 1 mole of zirconium metal ion.
- 15 6. A mixture of one or more water dispersible, hydrophilic, organic polymers having a molecular weight greater than 100,000 and containing carboxyl functionality, with a composition as claimed in any of Claims 1 to 5.
- 20 7. A composition according to Claim 6, wherein the or each said water dispersible hydrophilic organic polymer is carboxyalkyl guar wherein the alkyl group has 1 to 3 carbon atoms, carboxyalkylhydroxyalkyl guar wherein the alkyl groups have 1 to 3 carbon atoms, xanthan gum, polyacrylamide wherein  
25 5 to 75 percent of the carboxamide groups are hydrolized to carboxyl groups, polymethacrylamide wherein 5 to 75 percent of the carboxamide groups are hydrolyzed to carboxyl groups, cellulose ethers, a copolymer of 5 to 70 percent by weight acrylic or methacrylic acid and acrylamide or methacrylamide.  
30
8. A method of altering the permeability of a subterranean formation, which method comprises contacting said formation with an aqueous mixture comprising:
- 35 a. a water dispersible, hydrophilic, organic polymer having a molecular weight greater than 100,000 and containing carboxyl functionality; and



b. a composition as claimed in any of Claims 1 to 5.

9. A method of altering the permeability of a  
subterranean formation, which method comprises sequentially  
5 contacting the formation with:

a. a first aqueous mixture comprising a water  
dispersible hydrophilic organic polymer having a molecular  
weight of at least 100,000 and containing carboxyl function-  
ality;

10 b. a composition as claimed in any of Claims 1 to 5;

c. a second aqueous mixture comprising a water dis-  
persible hydrophilic organic polymer having a molecular  
weight of at least 100,000 and containing carboxyl function-  
ality.

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